



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2281

Job Sheet 168170



Part No: D2281

Job Qty: 50 ea

Part Name: Jack Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/10/17

Job Tracking No:

Due Date: 11/20/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV G IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPP: rev B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		11/18/17	0.00	0.00	Start Up Waterjet1		SC
100	Waterjet	50 pcs		11/18/17	0.00	2.62	Waterjet1		SC
120	QC	50 pcs		11/18/17	0.00	0.00	QC8		
130	Small Fab	50 pcs		11/18/17	0.00	1.55	Small Fab		SB
140	Brake NC	50 pcs		11/20/17	0.01	1.26	Brake NC 1		SB
150	QC	50 pcs		11/20/17	0.00	0.00	QC5		17-11-22/17
160	Packaging	50 pcs		11/20/17	0.00	0.00	Packaging3		SC
170	QC21-SA	50 Ea		11/20/17	0.00	0.00	QC21		

Part Op 100 - ISSUE PO ~~100~~ CUT PER DRWG D2281 REV. G

Descriptions: 130 - Deburr

140 - Form as per D2281 using D2281-T2

160 - LOCATION : WA001

NOV 22 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S14GA	6	25	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Jack Saddle	4.468Inches $\pm$ 0.010	4.478 4.458		
2	Jack Saddle	4.114Inches $\pm$ 0.010	4.124 4.104		
3	Jack Saddle	2.933Inches $\pm$ 0.010	2.943 2.923		
4	Jack Saddle	1.535Inches $\pm$ 0.010	1.545 1.525		
5	Jack Saddle	0.354Inches $\pm$ 0.010	0.364 0.344		
6	Jack Saddle	0.354Inches $\pm$ 0.010	0.364 0.344		
7	Jack Saddle	0.604Inches $\pm$ 0.010	0.614 0.594		
8	Jack Saddle	2.000Inches $\pm$ 0.010	2.010		

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only

☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :

Step #:

MBB (OS1042) Approval

Description Work Order Deviation

Job No: 168170
Mfg Date: 11/17/17

Start up Operation

Change No:
Operation:

ed By

Revision:

Supervisor
Verification

D2281

PART NO:

Jack Saddle

ordinator
val



S010829



Wrong
mensions
er tolerance
rect

Root Cause	
Environment	☐
Design	☐
Doc/Data	☐
Equip/Tooling	☐
Handling/Pre	☐
Material	☐
Internal Transport	☐
Tribal Knowledge	☐
LOA	☐
Substation	☐
Past Expiry Date	☐
Misidentified	☐
No Re-verification	☐
Operator	☐
Offset/Setup	☐
Supplier	☐
Training	☐
Use for Testing	☐
Poor Information	☐
Rushing	☐
Product Improvement	☐
Process Improvement	☐
Manufacturing Process	☐
Past Due	☐

☐	Pressure/Force
☐	Bending
☐	Centre Not Con
☐	Cracks
☐	Crimp/Kink/Ripple/Wave
☐	Cuffs
☐	Crushing
☐	Heat Treat
☐	Wave/Twist in Tube
☐	Marks/Chatter
☐	OTHER :

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Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

☐	Inspection Incomplete/Unqualified
☐	Contamination
☐	Countersink
☐	Cut Too Short
☐	Instructions Incomplete/Unclear
☐	Drill Holes
☐	Wrong Stock Pulled
☐	Out of Sequence
☐	Off-set
☐	Mislabeled
☐	Fit/Function
☐	Misaligned/off center
☐	Part Lost/Missing
☐	Part Moved
☐	Drawing
☐	Finish
☐	Misread
☐	Turning Sequence

			1.990	
9	Jack Saddle	3.396Inches ± 0.010	3.406 3.386	
10	Jack Saddle	3.646Inches ± 0.010	3.656 3.636	
11	Jack Saddle	4.000Inches ± 0.010	4.010 3.990	
12	Jack Saddle	1.525Inches ± 0.010	1.535 1.515	
13	Jack Saddle	2.475Inches ± 0.010	2.485 2.465	
14	Jack Saddle	0.323Inches $\begin{matrix} + 0.006 \\ - 0.001 \end{matrix}$	0.329 0.322	Diameter
15	Jack Saddle	0.080Inches ± 0.010	0.090 0.070	

Plex 11/10/17 10:51 AM Dart.lajeunesse.marie

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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DART AEROSPACE LTD		Work Order: 168170
Description: Jack Saddle		Part Number: D2281
Inspection Dwg: D2281	Rev: G	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4,470	1		VDC-Q2	
4.114	+/-0.010	4,112	1			
2.933	+/-0.010	2,930	1			
1.535	+/-0.010	1,530	1			
0.354	+/-0.010	0,352	1			
0.354	+/-0.010	0,352	1			
0.604	+/-0.010	0,603	1			
2.000	+/-0.010	2,000	1			
3.396	+/-0.010	3,394	1			
3.646	+/-0.010	3,645	1			
4.000	+/-0.010	4,000	1			
1.525	+/-0.010	1,524	1			
2.475	+/-0.010	2,473	1			
Ø0.323	+0.006/-0.001	Ø0,324	1			
0.080	+/-0.010	0,073	1			

Measured by: SC	Audited by: DAS 38	Prototype Approval: N/A
Date: 17/11/16	Date: NOV 17 2017	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____		Work Order update only ☐										
Work Order: _____ Part No. _____ NCR No. _____			DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS							
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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval				
Description Work Order Deviation					Disposition					Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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